



~~DED STYLE~~

Date: Tuesday, 15/08/2006 7:17:00 AM  
User: Linda Lacelle







**Process Sheet**

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BRACKET ASSEMBLY	
<b>Job Number</b> :	28158	<b>Part Number</b> :	D2803043	
<b>Estimate Number</b> :	11032	<b>Drawing Number</b> :	D2803 REV B	
<b>P.O. Number</b> :	N/A	<b>Project Number</b> :	N/A	
<b>This Issue</b> :	15/08/2006	<b>S.O. No.</b> :	N/A	
<b>Prsht Rev.</b> :	NC	<b>Drawing Revision</b> :	B	
<b>First Issue</b> :	N/A	<b>Material</b> :	N/A	
<b>Previous Run</b> :	25710	<b>Due Date</b> :	08/09/2006	<b>Qty:</b> 8 <b>Um:</b> Each
<b>Written By</b> :				
<b>Checked &amp; Approved By</b> :				
<b>Comment</b> :	Est D 05.03.30 MS21043-3 was MS21042L3 KJ/JLM			

**Additional Product**

Job Number:



Seq. #:	Machine Or Operation:	Description :								
1.0	D28031	STA 84 Bracket								
 										
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s) STA 84 BRACKET Pick: <table border="0"> <tr> <td>Qty</td> <td>Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>1</td> <td>D2803-1</td> <td>Bracket</td> <td>B27684</td> </tr> </table>			Qty	Part Number	Description	Batch	1	D2803-1	Bracket	B27684
Qty	Part Number	Description	Batch							
1	D2803-1	Bracket	B27684							
2.0	D28053	Stop								
 										
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s) STOP Pick: <table border="0"> <tr> <td>Qty</td> <td>Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>1</td> <td>D2805-3</td> <td>Stop</td> <td>B25715 smc 3 B28428<sup>182</sup></td> </tr> </table>			Qty	Part Number	Description	Batch	1	D2805-3	Stop	B25715 smc 3 B28428 <sup>182</sup>
Qty	Part Number	Description	Batch							
1	D2805-3	Stop	B25715 smc 3 B28428 <sup>182</sup>							
3.0	D2809	Bushing								
 										
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s) Bushing Pick: <table border="0"> <tr> <td>Qty</td> <td>Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>1</td> <td>D2809</td> <td>Bushing</td> <td>B27617 ✓</td> </tr> </table> <p>Press D2805-3 into arm as per Dwg D2803</p> <p>SB 06/09/04</p> <p>SB 06/09/01</p>			Qty	Part Number	Description	Batch	1	D2809	Bushing	B27617 ✓
Qty	Part Number	Description	Batch							
1	D2809	Bushing	B27617 ✓							

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:17:00 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 28158

Part Number: D2803043

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

QC5



Inspect press f.t.



06-09-05

PTC

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

am

06-09-05

8

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/09/05

8

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2803

mf. 06/09/05

8

8.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

2 AN3C16A Bolt

07/10/1189 v

AL 06/08/31

9.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch

2 MS21043-3 Nut

07/19099

AL 06/08/31

10.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 32.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

4 NAS1515H3 Washer

A/R LPS-3 Corrosion Spray

07/100993  
mi 1045

AL 06/08/31  
mf. 06/09/05

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-09-05	4.0	QC 5 req'd to inspect Press fitting. Not Machining. Perm. Change <i>[Signature]</i>					<i>[Signature]</i> 06-09-05

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 06/09/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 15/08/2006 7:17:01 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 28158

Part Number: D2803043

Job Number:



Seq. #:

Machine Or Operation:

Description :

Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803

M101472

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2803.

MF 06/09/05

(8)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/09/05

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST157

P06/9/05

(8)

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/07/02

(8)

Job Completion



U 06-09-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
	U							

NOTE: Date & initial all entries

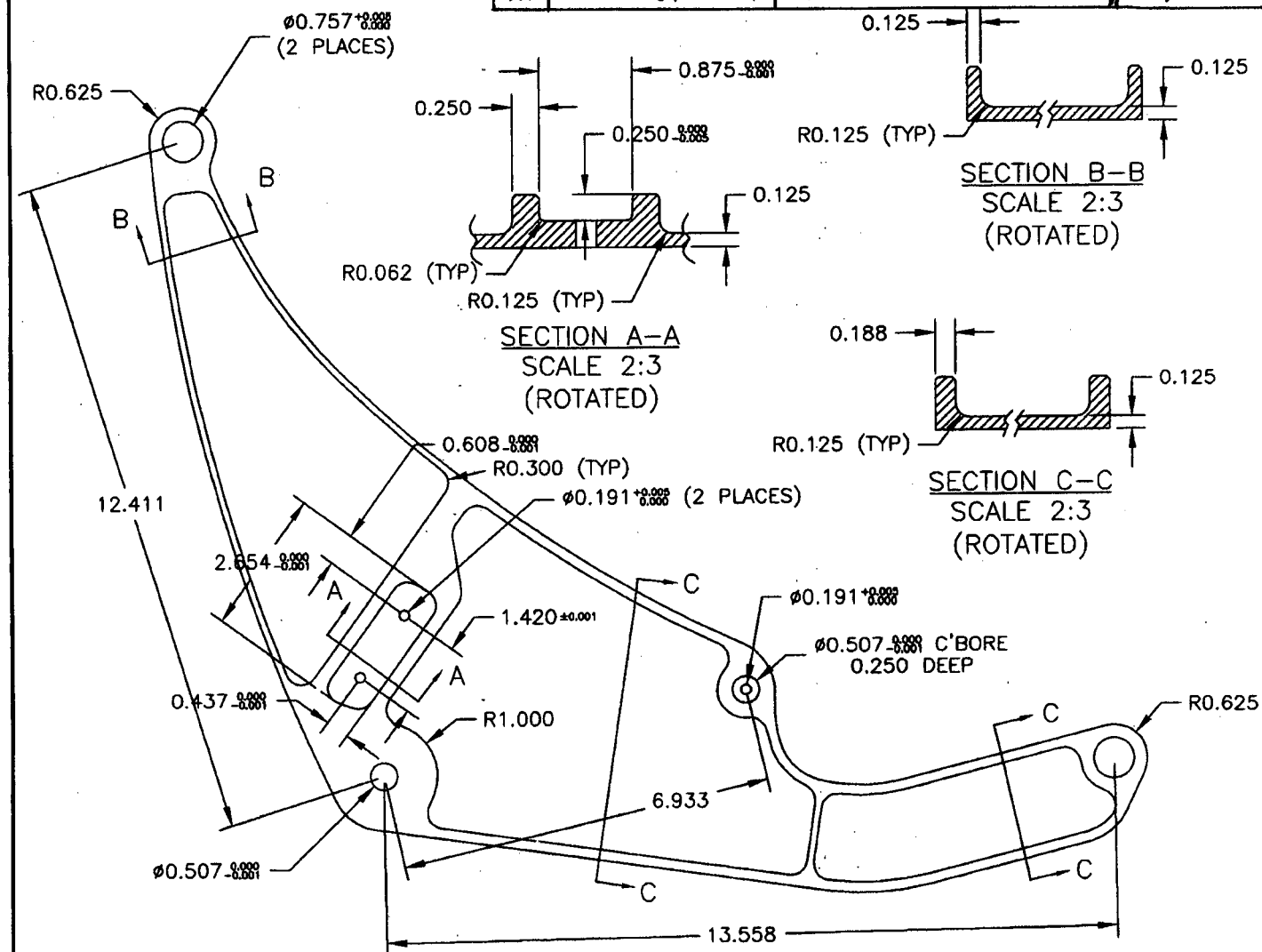
SUPERCEDED BY

05.02.18

**DART**



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED	DRAWING NO. D2803	REV. A SHEET 1 OF 2
DATE 00.11.07		TITLE STA 84 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
A1	01.03.14	ADD D2803-043/-044 CP	



D2803-1 (SHOWN)  
D2803-2 (OPPOSITE)

**RELEASED**  
00.11.13

MACHINE PER DRAWING FILE "D2803-A1.DWG"  
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK  
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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